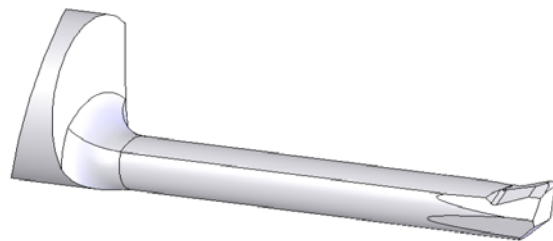
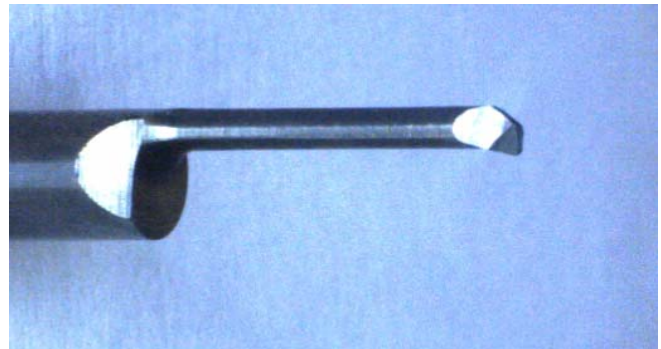















ID Turning tool with dxQ Profile

A17-010

This turning tool with excentric shaft is used for turning small pieces on high precision lathe machines. The tool is ground out of a blank with Ø4x37mm. The excentric profile grinding option of Quinto allows to grind the excentric shaft based on DXF. The main profile is ground with dxQ operations of Quinto.



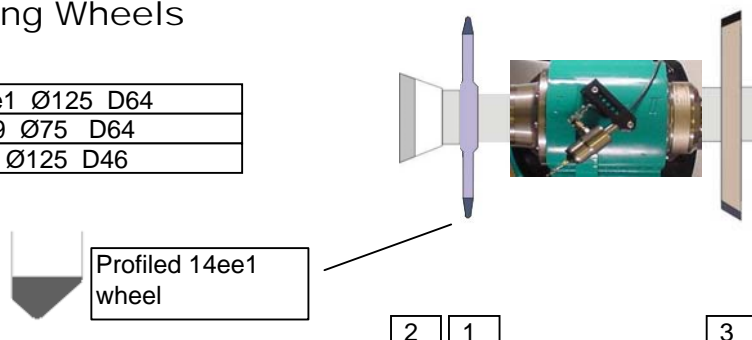
1. Cycletime for Production

Workpiece: Diameter 4 mm, Z 1, Length 11 mm Material CARBIDE							
Operations							
Feed [mm/Min]	2000	50	100	40	40	40	600
No. Of cycles		5	1	1	1	1	1
Cutting feed [m/s]		22	22	22	22	22	24
Used wheels							
Grinding time [s]	6	80	20	19	19	20	201
Total cycle time	06 Min 05 sec						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	14ee1 Ø125 D64
2	11V9 Ø75 D64
3	1V1 Ø125 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG / SIRIUS HPM
Control: Fanuc 320i
Accessories: STL6051

Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

Responsible engineer: HEM, 31.03.2011

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